

Work Order ID 94257***94257***

Tuesday, December 04, 2012 8:30:31 AM

Page 1

Item ID: D3705-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: COVER PLATE

Stop ***NS2***

Start Date: 12/4/2012 Start Qty: 2.00

Required Date: 12/6/2012 Req'd Qty: 1.00

Cust Item ID:

Customer:

PRELIMINARY ISS

Reference:

Approvals:

Process Plan: CNFDate: 12-12-04 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3705

PE1

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3705

Dwg Rev: PE1Prog Rev: PE1

***grain direction ***

2- Deburr if necessary

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

2 0 Jm 12-12-4

2 0 Jm 12-12-4

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Work Order ID 94257

94257

Page 2

Tuesday, December 04, 2012 8:30:31 AM

Item ID: D3705-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: COVER PLATE
 Start Date: 12/4/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/6/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							
						2			Inspect as per DWG PEI
130 *130* Small Fab Small Fab	Small Fab Memo 1- COUNTER SINK AS PER DWG 2- BEND AS PER DWG D3705	0.00 0.00							
						2x			12/12/04 SH 12/12/04
140 *140* QC Quality Control	QC5- inspect part completeness to step on W/O Memo	0.00 0.00							
						2			Inspect as per DWG PEI

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped.	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misleading
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Work Order ID 94257

94257

Page 3

Tuesday, December 04, 2012 8:30:31 AM

Item ID: D3705-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: COVER PLATE
 Start Date: 12/4/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/6/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <i>prelim.</i> Memo	0.00 0.00		<i>MF</i> <i>12-12-05</i>					
160 *160* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

POSITIVE RECALL
 EFFECTIVE 12/12/05 AUTH *u*
 RELEASED _____ DATE _____

MF
12-12-05

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
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		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Picklist Print

Tuesday, December 04, 2012 8:30:31 AM

Page 1

Work Order ID: 94257

Parent Item: D3705-3**Start Date:** 12/4/2012

Required Date: 12/6/2012

Parent Item Name: COVER PLATE

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A 08-01-30 new issue EC verified by:DD

IPP Rev:B 09-01-09 rev.c as per dwg DD verified by:EC

IPP Rev:C as per dwg RevD DD

10.04.27 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	295.5843	0.74	0.7789474			
6061-T6 .080 Sheet													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT021		295.584316							
				117285		0.124316							
				119766		20.66							
				120096		84.4							
				123279		190.4				123279			

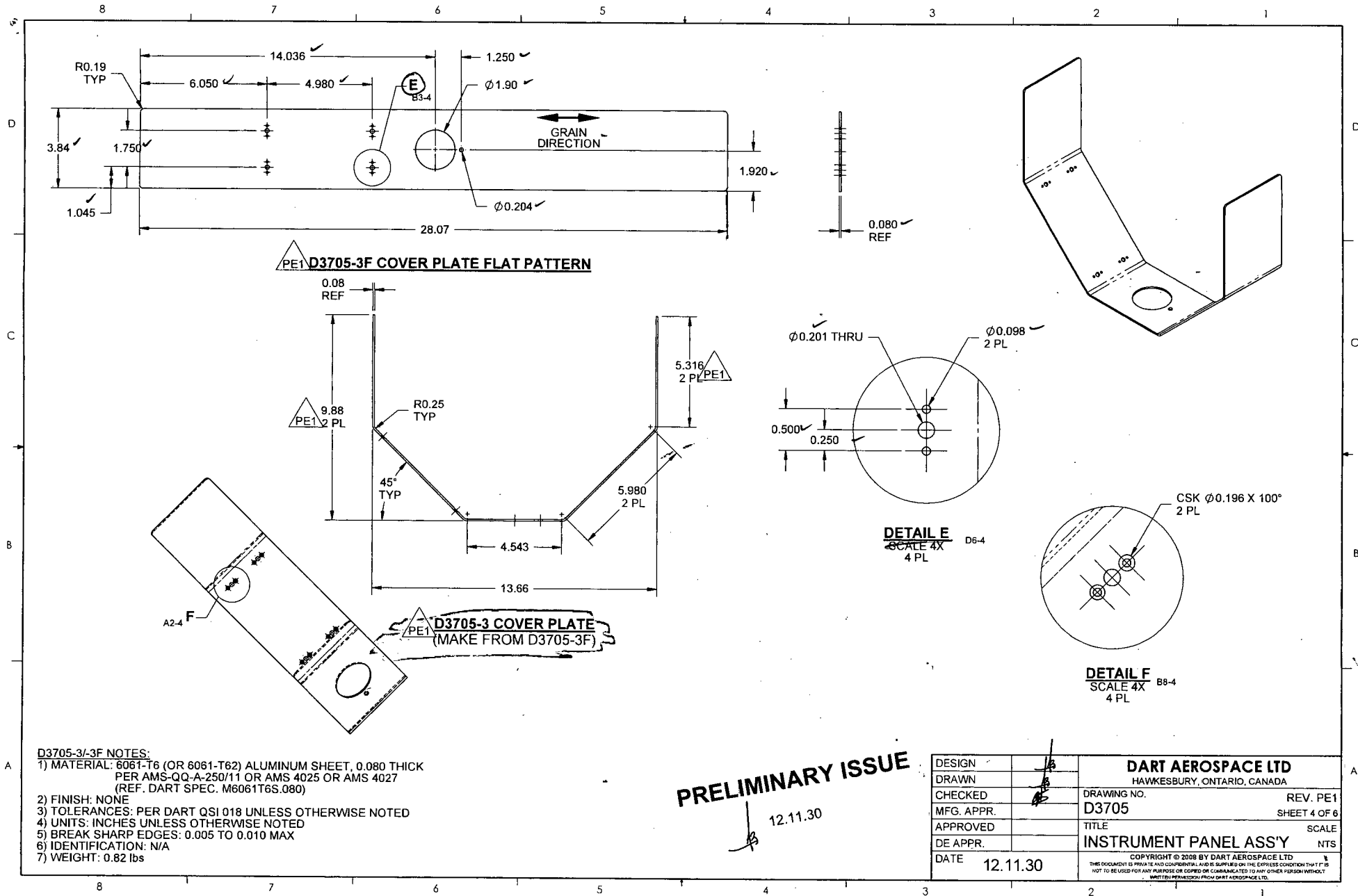
NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
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Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		



D3705-3/-3F NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.82 lbs

PRELIMINARY ISSUE

12.11.30

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PE1
MFG. APPR.		D3705	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		INSTRUMENT PANEL ASS'Y	NTS
DATE	12.11.30	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

FIRST ARTICLE INSPECTION CHECKLIST

Measured by: Jm	Audited by: 15	Preliminary Approval:
Date: 12-12-4	Date: 12/12/09	Date:

Receiving Report

Date: 12/10/10

Batch No: M/23279

Supplier: TITXGOSKINUPA

Dart P/O: 18068

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☐ No ☒ N/A ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection 19 12/10/11 N/A ☒
 Work Order: 85 N/A ☐

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M606176	80-375X0.100	318	36	0	12	
M30451860		192	160	0	32	
M2024	FS3.0190	48	0	0	48	

Initials of receiver (if shipment OK) Level 12 [Signature]

Production/Admin: 12/10/10
 Date
 Received/Costing
 Initial [Signature]

Location _____

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Vendor Name VC-COP001 Thyssenkrupp Materials CA Ltd											
PO18068	8		M6061T6B00750X00 f .125		10/10/2012	10/10/2012	100.0000	\$0.36	0.0000	0	\$36.11
CAD	No		6061-T6 Bar .750 x f .125 123279		100.0000	DESJ02		\$36.11	0.0000	0	
	9		M6061T6B1.000X02. f 000		10/10/2012	10/10/2012	24.0000	\$4.92	0.0000	0	\$117.98
	No		6061-T6 Bar 1.00 x f 2.00 123279		24.0000	DESJ02		\$117.98	0.0000	0	
	10		M6061T6B0.625X01. f 500		10/10/2012	10/10/2012	12.0000	\$2.24	0.0000	0	\$26.85
	No		6061-T6 Bar .625 x f 1.50 123279		12.0000	DESJ02		\$26.85	0.0000	0	
	11		M6061T6B0.187X04. f 000		10/10/2012	10/10/2012	60.0000	\$1.93	0.0000	0	\$115.95
	No		6061-T6 Bar .187 x f 4.00 123279		60.0000	DESJ02		\$115.95	0.0000	0	
	12		M6061T6B2.000X02. f 250		10/10/2012	10/10/2012	12.0000	\$11.75	0.0000	0	\$140.97
	No		6061-T6 Bar 2.00 x f 2.25 123279		12.0000	DESJ02		\$140.97	0.0000	0	
	13		M6061T6S.080 sf		10/10/2012	10/10/2012	288.0000	\$2.72	0.0000	0	\$783.98
	No		6061-T6 .080 Sheet sf 123279		288.0000	DESJ02		\$783.98	0.0000	0	
	14		M6061T6S.090 sf		10/10/2012	10/10/2012	96.0000	\$3.06	0.0000	0	\$293.99
	No		6061-T6 .090 Sheet sf 123279		96.0000	DESJ02		\$293.99	0.0000	0	
	15		M6061T6S.125 sf		10/10/2012	10/10/2012	144.0000	\$4.20	0.0000	0	\$604.72
	No		6061-T6 .125 Sheet sf 123279		144.0000	DESJ02		\$604.72	0.0000	0	
Total Received Quantity:											1,072.0000
Total Qty to Inspect (PO U/M):											0.0000
Total Reject Quantity:											0.0000
Total Receipt Value:											\$3,412.59
Total Balance Due Quantity:											44.0000

B I L L O F L A D I N G

No: PEC 789038

Ship From:

THYSSENKRUPP MATERIALS NA
2821 LANGSTAFF ROAD
CONCORD, ONTARIO L4K 5C6
Tel: 905 669 9444 Fax: 9057389033

Ship Date 09Oct12 at 13:18 From PFV
Probill

Via VIM TRANSFER

FOB CONCORD

Frt PREPAID

Route 0- 0 Manifest

Vhcle Trailer

Slp STAN IVERS (905-532-1350)

Sold To: (20115)

DART AEROSPACE

Ship To: (1)
DART AEROSPACE

B I L L O F L A D I N G

Heat Number	Tag No	Quantity	PCS	Wt LBS
201214546	111528	12 FT	1	14

11) Our Order PEC-497102- 11 Your PO # 18068

ALUMINUM FLAT BAR 6061-T6511

.187" x 4.00" X 240.0000"

Heat Number	Tag No
HK717 205	111487

MTR'S

Quantity
60 FTPCS
3Wt LBS
52

12) Our Order PEC-497102- 12 Your PO # 18068

ALUMINUM FLAT BAR 6061-T6511

2.00" x 2.50" X 144.0000"

Heat Number	Tag No
HK118 102	111529

MTR'S

Quantity
12 FTPCS
1Wt LBS
70

13) Our Order PEC-497102- 13 Your PO # 18068

ALUMINUM SHEET 6061 T6

.0810 Nom X 48.0000" X 144.0000"

Heat Number	Tag No
25872/01/00	111612

MTR'S

Quantity
288.00 SFTPCS
6Wt LBS
315

14) Our Order PEC-497102- 14 Your PO # 18068

ALUMINUM SHEET 6061 T6

.0910 Nom X 48.0000" X 144.0000"

Heat Number	Tag No
27049/01/00	111614

MTR'S

Quantity
96.00 SFTPCS
2Wt LBS
119

15) Our Order PEC-497102- 15 Your PO # 18068

ALUMINUM SHEET 6061 T6

.1250 Nom X 48.0000" X 144.0000"

Heat Number	Tag No
25875/01/00	111615

MTR'S

Quantity
144.00 SFTPCS
3Wt LBS
251

TOTAL:	Tags	PCS	LBS
	16	43	1437

Page: 3Continued

TOUTES ERREURS ET/OU MARCHANDISES MANQUANTES DOIVENT ÊTRE
RAPPORTÉES IMMÉDIATEMENT.

ERRORS OR SHORTAGE MUST BE REPORTED IMMEDIATELY.

RETOUR DE MARCHANDISES AVEC NOTRE NUMERO D'APPROBATION SEULEMENT.
MERCHANDISE MAY NOT BE RETURNED WITHOUT OUR APPROVAL NUMBER.

18 OCT. 2012

THYSSENKRUPP MATERIALS NA

Certificate of Mill Test Results

DART AEROSPACE

PO/Rel 18068

BL PEC-789038-013

9Oct12

ALUMINUM SHEET 6061 T6
.0810 Nom X 48.0000" X 144.0000"
PART NO.

We certify that this is a true copy of the report
furnished by the producer of the metal, or data
resulting from tests made in approved labs.

Signed by: _____

Pg 1/2



Abnahmeprüfzeugnis 3.1 (EN 10204) Inspection certificate – mill certificate

Nr.: 85289222 02 / 7

Rev. 0

Seite / page: 1 von / of 2

Datum / date: 2012 02 15

Zertifiziert nach / certified to ISO 9001, ISO/TS 16949, EN/AS 9100, ISO 14001, NADCAP

Auftraggeber / customer: ThyssenKrupp Materials NA 2821 Langstaff Rd CDN-L4K 506 CONCORD, ON Warenempfänger / consignee: ThyssenKrupp Materials NA 2821 Langstaff Rd CDN-L4K 506 CONCORD, ON Endkunde, Bestell-Nr. / Your cust., ord. no.:	Bestell Nr. / order no.: PEC-236262 Datum / date: 2012 01 19
	Auftragsbest. Nr. / order confirm. no.: 636296 Datum / date: 2012 01 20
	Lieferschein Nr. / delivery note: 85289222 Datum / date: 2012 02 29
	Akkreditiv Nr. / letter of credit no.:

Produkt/product	Bedingungen/terms
Form / form: Sheet Werkstoff / material: 6061 Zustand / temper: T6 Dim. / dim: [inch]: 0,080x48,00x144,00 Kundenartikel-Nr / customer article no.:	Techn. Lieferbedingungen / techn. spec.: AMS-QQ-A-250/11, 08.1997 ASTM B 209 - 07 Material meets also the mech. properties of AMS 4027N, 07.2008, but not marked ANSI H35.2-2009 ASME SB 209, 2007 Sondervorschrift / special terms:

AB-Pos. ord./item.	BNr/Los/Tellios Lot/No./Part	Guss Nr. cast no.	Werkstoff material	Kollo. packno.	Gewicht netto weight net	Stk. pcs.
02	25872/01/00	01/0047294/1	6061.1	6362960002	4029,982 lbs	77

Chemische Zusammensetzung / chemical composition: [%] Gewichtsanteile / weight proportion (OES)										
Guss Nr. / cast no.	AMAG designation	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti
01/0047294/1	6061.1									
	actual	0,65	0,48	0,23	0,11	0,91	0,18	0,01	0,04	0,06

Zugversuch / Tensile test									
BNr/Los Lot/No.	Zustand temper	Richtung direction			Rm [ksi]	Rp0.2 [ksi]	A2" [%]		
25872/01	T6	LT			47,0	39,2	16		
25872/01	T6	LT			47,1	39,2	15		
25872/01	T6	LT			47,3	39,3	15		
25872/01	T6	LT			47,0	39,2	16		
25872/01	T6	LT			46,8	39,0	16		
25872/01	T6	LT			46,7	38,9	15		
25872/01	T6	LT			46,7	38,9	15		
25872/01	T6	LT			46,8	39,0	16		
25872/01	T6	LT			46,6	38,7	15		

DA
14
2-89 12/10/11

AMAG rolling GmbH, Postfach 32, A-5282 Ranshofen, Österreich – www.amag.at
AMAG rolling GmbH, P.O. Box 32, A-5282 Ranshofen, Austria – www.amag.at



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO18068**

Purchase Order Date 10/04/12

PO Print Date 10/04/12

Page Number 5 of 6

Order From :

VC-COP001

THYSSENKRUPP MATERIALS CA LTD
O/A VPK METAL- C/O T27540/PO BOX 4275,POSTAL"A"
TORONTO, ON M5W 5V8
CA

Contact Name

Vendor Phone

905 669 9444

Vendor Fax

905 738 9033

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

13	M6061T6S.080 021	6061-T6 .080 Sheet	10/10/12 Yes	288.00 sf	Yours ppd	\$2.6764	\$770.80
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Special Inst:

MATERIAL: 6061-T6/T62 ALUMINUM
SHEET
AS PER QQ-A-250/11 OR AMS-QQ-A-
250/11 OR
AMS 4025 OR AMS 4027 OR ASTM B209

14	M6061T6S.090 021	6061-T6 .090 Sheet	10/10/12 Yes	96.00 sf	Yours ppd	\$3.0109	\$289.05
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Special Inst:

MATERIAL: 6061-T6/T62 ALUMINUM
SHEET
AS PER QQ-A-250/11 OR AMS-QQ-A-
250/11 OR
AMS 4025 OR AMS 4027 OR ASTM B209

15	M6061T6S.125 021	6061-T6 .125 Sheet	10/10/12 Yes	144.00 sf	Yours ppd	\$4.1288	\$594.55
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Special Inst:

MATERIAL: 6061-T6/T62 ALUMINUM
SHEET
AS PER QQ-A-250/11 OR AMS-QQ-A-
250/11 OR
AMS 4025 OR AMS 4027 OR ASTM B209

16	M2024T3S0.190	2024-T3 .190 sheet	10/10/12 Yes	48.00 sf	Yours ppd	\$13.9583	\$670.00
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P. Lavoie
**MATERIAL CERTIFICATION
REQ'D UPON DELIVERY**

No substitution or deviation without
consent.

Certificate of Conformity or Material
Certification required **YES** NO

Change Nbr: 2

Change Date: 10/04/12

